

Work Order ID 69793

Thursday, May 19, 2011 12:34:03 PM

*Ship today*

Page 1

Item ID: D407-802-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, RH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *mk* Date: *11-05-19* Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-012 CHG001

*8/10/19**NA*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/6/19

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/10/19**(XU)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69793

Thursday, May 19, 2011 12:34:03 PM



Page 2

Item ID: D407-802-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, RH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-802-012

Location: _____

PPP rev: _____

PP 69793

11/5/19

130

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/5/19

MF
4-05-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 12:33:57 PM

Page 1

Work Order ID: 69793

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH


Start Date: 5/19/2011

Required Date: 5/19/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 10.12.02 per revA DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15  Door Prop		Manufactured	No			105	Each	29.0000	1	1			


Location	Loc Qty	Loc Code
ST272	17	
64402	17	
ST272A	12	
65119	12	

D3622-5  Ball Stud		Manufactured	No			105	Each	54.0000	2	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST070	54	
64330	14	
64428	20	
65087	20	

D4106-2  Sill Doulber, RH		Manufactured	No			105	Each	7.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST127	7	
64332	7	

D4106-4  Crew Door Doulber, RH		Manufactured	No			105	Each	4.0000	1	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
st128	4	
64334	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 12:33:57 PM

Page 2

Work Order ID: 69793

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4106-5



Spacer, Sill Douber

Manufactured No

105

Each

20.0000



1

1

Location

Loc Qty

Loc Code

ST127

20

62296

4

64335

8

64341

8

1

D4106-7



Template

Manufactured No

105

Each

13.0000



1

1

Location

Loc Qty

Loc Code

ST127

13

62295

1

64336

12

CR3523-4-02



RIVET

Purchased No

105

Each

335.0000



26

26

Location

Loc Qty

Loc Code

ST312

232

116915

132

117291

100

ST313

103

116391

100

116893

3

26

CR3523-4-4



Rivet

Purchased No

105

Each

90.0000



4

4
11/5/19

Location

Loc Qty

Loc Code

ST314

90

115768

90

4

Thursday, May 19, 2011 12:33:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 12:33:57 PM

Page 3

Work Order ID: 69793

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-5

Purchased

No

105

Each

100.0000

3



Rivet

Location

Loc Qty

Loc Code

ST313

100

117423

100

CR3523-4-6

Purchased

No

105

Each

200.0000

8



Rivet

Location

Loc Qty

Loc Code

ST314

200

115768

100

116606

100

CR3523-4-07

Purchased

No

105

Each

169.0000

7



RIVET

Location

Loc Qty

Loc Code

ST313

169

116606

100

17768

69

MS20426AD4-5

Purchased

No

105

Each

5,782.000

4



Rivet

Location

Loc Qty

Loc Code

MEZZ

493

6733

493

ST317

5289

6874

5289

Thursday, May 19, 2011 12:33:57 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 12:33:57 PM

Page 4

Work Order ID: 69793

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

147.0000

2

2



nut plate

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

47

113660

27

116583

20

NAS1149C0532R

Purchased

No

105

Each

348.0000

6

6



WASHER

Location

Loc Qty

Loc Code

ST297

348

116289

48

116373

100

116513

200

NAS1149C0563R

Purchased

No

105

Each

574.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST297

574

112532

100

115768

74

116391

200

117460

200

Thursday, May 19, 2011 12:33:57 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

5

5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4106-1	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
1		D4106-3	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

